

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015916**Date Inspected:** 26-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

OBG Seg 9BW to Seg 9CW:

This QA Inspector observed the following work in progress:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG051A-043. The welder was identified as 068746 and was observed welding in the 4G position. ZPMC Quality Control (QC) was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The SMAW process on weld joint no: SEG053A-013. The welder was identified as 068746 and was observed welding in the 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

The SMAW process on weld joint no: SEG051A-021. The welder was identified as 045196 and was observed welding in the 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared

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to comply with WPS: B-P-2214-B-U2-FCM-1.

The SMAW process on weld joint no: SEG053A-014. The welder was identified as 066326 and was observed welding in the 4G position. ZPMC QC was identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-B-U2-FCM-1.

OBG Seg 9CE to Seg 9DE:

Repair welding on weld joint no: OBE9C-003. Welding process was identified as SMAW. The welder was identified as 048659 and was observed welding in the 4G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Critical Welding Report (CWR): B-CWR-1704 Rev-0. See attached photo for further details.

The Flux Cored Arc Welding (FCAW) process on weld joint no: BK001-041-005 and 007. The welders were identified as 220066 and 051246 and were observed welding in the 3G position. ZPMC QC was identified as Wang Liang. The welding variables recorded by QC appeared to comply with WPS: B-P-2233-T.

Bay 16:

Notification no: 006287.

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC QC personnel. This QA Inspector has generated MT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

1) LD3033-001-001 to 005.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
